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D4653-7

Job Sheet 201747



Part No: D4653-7

Job Qty: 24 pcs

Part Name: Fitting, Large



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/19

Job Tracking No:

Due Date: 10/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12-06-11 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	24 pcs	10/24/19	10/24/19	0.26	4.44	Doosan - 1		10/11/16 SBL
120	QC 8	24 pcs	10/24/19	10/24/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		SBL 19/11/16
							QC 8 - 76		
							QC 8 - 61		
130	Packaging 3-1 - Stock - B4B	24 pcs	10/24/19	10/24/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	12
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	24 pcs	10/24/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 130 - (Identify as per dwg & Stock Location: 140)
 140 - (QC21- Final Inspection - Work Order Release)

NOV 18 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.000	Round Bar 1.00"	4.2000 ft (.175 ea)	100-Doosan - 1	S229480

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R1.000	4	54	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Large Fitting	1.380Inches $\pm$ 0.030	1.410 1.350		
2	Large Fitting	0.250Inches $\pm$ 0.010	0.260 0.240		
3	Large Fitting	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
4	Large Fitting	0.0940inches $\pm$ 0.0300	0.1240 0.0640	Radius	
5	Large Fitting	2.120Inches $\pm$ 0.030	2.150 2.090		
6	Large Fitting	0.825Inches $\pm$ 0.010	0.835 0.815	Diameter	
7	Large Fitting	0.547Inches $\pm$ 0.010	0.557 0.537	Diameter	
8	Large Fitting	0.0990inches $\pm$ 0.0100	0.1090 0.0890		
9	Large Fitting	0.745Inches + 0.000 - 0.005	0.745 0.740	Diameter	

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Entered: _____ Date: _____
NCR No. _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date: _____	Sequence #: _____	QTY Affected: _____				MRB (QS1042)	
Description Work Order Deviation		Disposition					
						Completed By	
						Lead hand / Supervisor	
						QC / QA Coordinator	
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		